

Date: Thursday, 20/11/2008 3:34:21 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BACK FRAME ASSEMBLY	
Job Number	: 43601		Part Number	: D3017041	
Estimate Number	: 11129		Drawing Number	: D3017 REV A	
P.O. Number	:		Project Number	: N/A	
This Issue	: 20/11/2008		Drawing Revision	: A	
Prsht Rev.	: NC		Material	:	
First Issue	: / /		Due Date	: 20/12/2008	
Previous Run	: 43380		Qty:	1 Um: Each	
Written By	:				
Checked & Approved By	: <u>JDP 08.11.21</u>				
Comment	: Est. A 01.09.19 New issue EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M4130NT0750W049	4130 RD Tube .750 x.049W	
		Comment: Qty.: 13.1250 f(s)/Unit Total : 13.1250 f(s) 4130 Tube .750 OD x.049W Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall m103012 → 11' Batch: A1013012 , m10133 → 673011	
2.0	D30177	Lug	
		Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) Lug Pick: Qty Part Number Description Batch 3 D3017-7 Lug B38567	
3.0	D301711	cap	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) cap batch: B42354	
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	

Comment: LARGE FABRICATION RESOURCE 1

1-Cut all tubes as per Dwg D3017

2-Bend tube as per dwg D3017

3-Drill holes in D3017-5 Using DT8622

4-Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BACK FRAME ASSEMBLY

Job Number: 43601

Part Number: D3017041

Job Number:



Seq. #: Machine Or Operation:

Description :

5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598
A/R 4130 Rod Batch: M15684

6-Drill holes in back frame using back panel drill jig DT8621

EL 9-175

5.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 9-2-25

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/25 00

7.0 POWDER COATING POWDER COATING



M109648

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 8:30AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:00AM

EW 09-02-26

(D)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EL 09-02-26

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 67

09-02-26

09-02-26

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09-02-26

Job Completion



MT
09-02-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

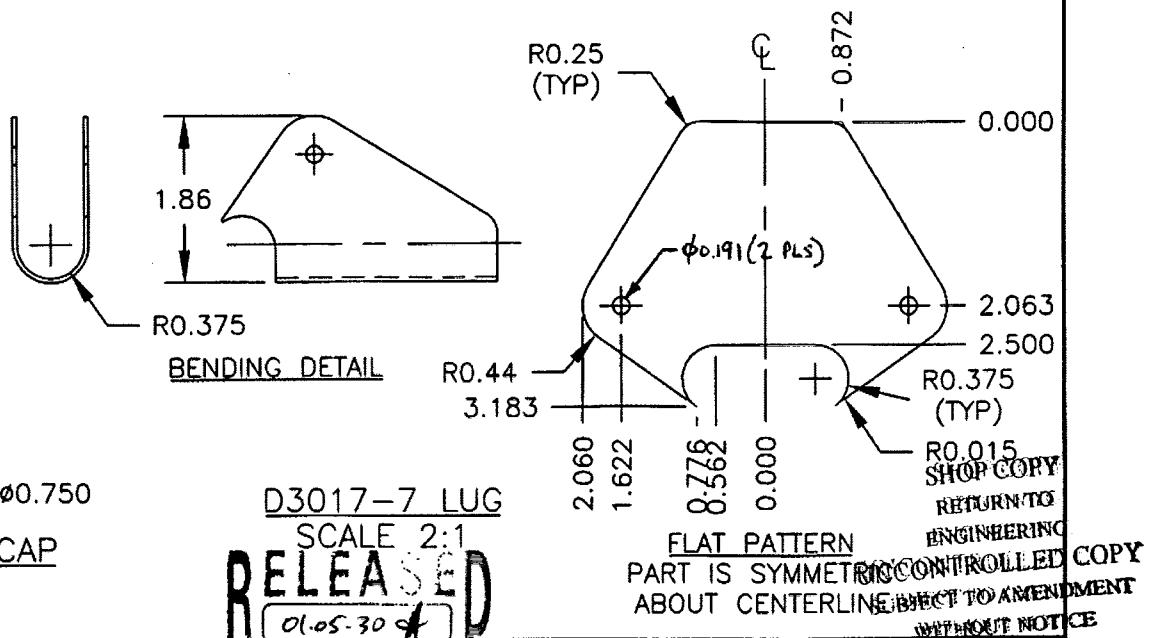


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>A</i>	APPROVED <i>dt</i>	DRAWING NO. D3017	REV. A	SHEET 1 OF 2
DATE 01.05.18		TITLE BACK FRAME ASSEMBLY	SCALE 1:1	
A	01.05.18	NEW ISSUE		

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



D3017-11 END CAP
SCALE 1:1

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